

# Work Order ID 66395

Monday, February 14, 2011 10:22:14 AM



Page 1

Item ID: D3407-3

Revision ID:

Item Name: Stem

Start Date: 2/14/2011 Start Qty: 8.00

Required Date: 2/21/2011 Req'd Qty: 8.00

Reference:

Accept

*For Blue gear*



Setup Start

Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: *mf*

Date: *11-02-14*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3407

Rev E

100

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA597 Rev *AA* & Dwg D3407 Rev: *E* □2-Deburr

*11.2.25 8 8*  
*1/SA 11/2/28*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*11.2.25 8 8*  
*1/SA 11/2/28*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*11/03/01 8 8*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 66395**

Monday, February 14, 2011 10:22:14 AM

Page 2

Item ID: D3407-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Stem

Start Date: 2/14/2011 Start Qty: 8.00

Cust Item ID:

Required Date: 2/21/2011 Req'd Qty: 8.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg & Stock Location: PARC

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/01

11/03/01

CZ 11/03/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Monday, February 14, 2011 10:22:11 AM

Page 1

Work Order ID: 66395

Parent Item: D3407-3

Parent Item Name: Stem




Start Date: 2/14/2011

Required Date: 2/21/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 05.10.18 New issue KJ/EC  
IPP Rev:B Now on Doosan 08-05-14 JLM Verified By:DD  
IPP Rev:C 08-08-12 revE as per dwg (ecn 08-507) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174R0.750  17-4 round bar .750		Purchased	No			100	f	33.8950	0.366	3.082105			

*Handwritten: 11.2.25*

Location

Loc Qty

Loc Code

MAT

33.895

114488

9.895

116808 ✓

24

*Handwritten: 3.125*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 66395
<b>Description:</b> Stem		<b>Part Number:</b> D3407-3
<b>Inspection Dwg:</b> D3407	<b>Rev:</b> E	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.063	+/-0.010	.063	/		.02	
1/4-28 UNF	Max: 0.2668 Min: 0.2635	.265	/			
Major Ø	Max: 0.249 Min: 0.2425	.243	/			
Ø0.625	+/-0.010	.623	/			
Ø0.363	+/-0.010	.360				
Ø0.750	+/-0.010	.749				
R0.100	+/-0.010	R.100				
0.470	+/-0.010	.470				
0.250	+/-0.010	.250				
2.555	+/-0.010	2.555				
3.305	+0.000/-0.010	3.300				
4.325	+/-0.010	4.321	/		Visual	SA-Q
0.150	+/-0.010	.154	/			
0.550	+/-0.010	.551	/			
0.625	+/-0.010	.623	/			
0.250	+0.010/-0.000	.252	/			

<b>Measured by:</b> [Signature]	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11/2/29	<b>Date:</b> 11/23/01	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.11.08	New Issue	KJ/JLM	
B	07.09.26	Tolerances revised	KJ/EC	
C	08.05.14	Dimensions updated per Dwg Rev D	KJ/JLM	
D	08.10.07	Dimensions updated per Dwg Rev E	KJ/DD	[Signature]

W/O:		WORK ORDER CHANGES					
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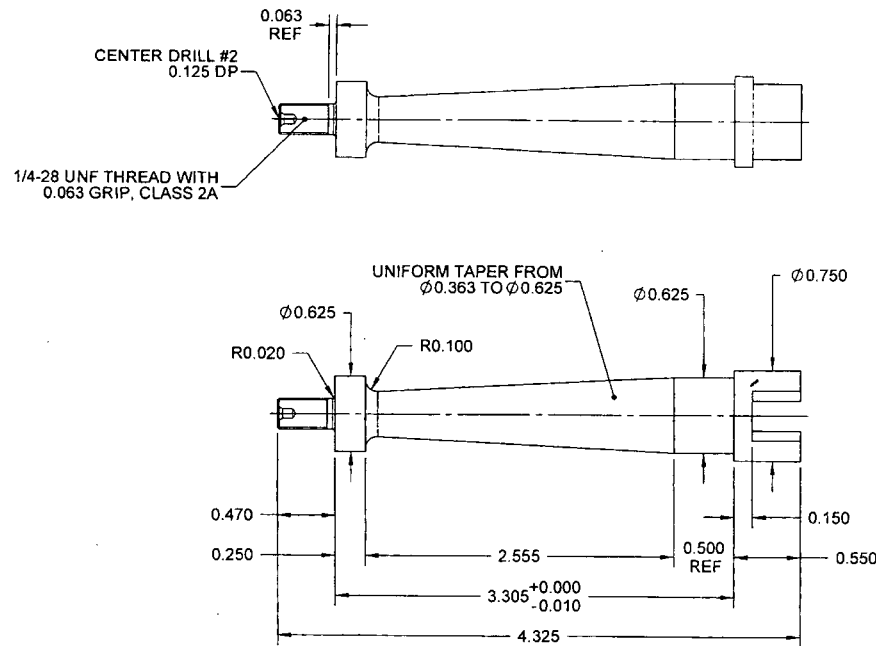
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





**D3407-3 STEM**

- NOTES:**
- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.27 lbs

DESIGN	112	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	114	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		<b>D3407</b>	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>TOW RING</b>	NTS
DATE	08.07.23	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

**RELEASED**  
08-08-01-114

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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